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CLAIMS:

1. A method of coating a substrate, the method comprising the steps of applying a coating composition to at least selected areas of the substrate, exposing the coated substrate to ultra-violet light from at least one lamp having a power output of at least 140 watts per linear centimetre in a curing zone, to initiate curing of the coating, the coating composition comprising a mixture including at least a reactive part comprising between 30% and 100% multi-functional material and being photo-initiator-free, including the step of maintaining a substantially inert atmosphere in the curing zone where the substrate is exposed to said ultra-violet light.

2. A method according to Claim 1 wherein the inert atmosphere is obtained by purging the said curing zone with inert gas.

3. A method according to Claim 2 wherein the inert gas comprises nitrogen.

4. A method according to ~~any one of the preceding Claims~~ Claim 1 wherein the oxygen concentration within the said curing zone is less than 1,000 parts per million.

5. A method according to Claim 4 wherein the oxygen concentration is less than 100 parts per million.

6. A method according to ~~any one of the preceding Claims~~ Claim 1 wherein the multi-functional material comprises one or more reactive diluents.

7. A method according to ~~any one of the preceding Claims~~ Claim 1 wherein the multi-functional material comprises one or more

materials, the or each material having a molecular weight in excess of 480.

8. A method according to ~~any one of the preceding Claims~~ Claim 1 wherein the multi-functional material comprises one or more materials which have three or more functional acrylate groups.

9. A method according to Claim 6, ~~7 or 8~~ wherein the coating material additionally contains a pre-polymer.

10. A method according to Claim 9 wherein the pre-polymer comprises polyester acrylate, polyurethane acrylate, epoxyacrelate, or a full acrylate material.

11. A method according to Claim 9 ~~or 10~~ wherein the pre-polymer is multi-functional.

12. A method according to ~~any one of the preceding Claims~~ Claim 1 wherein the coating composition comprises, in addition to the reactive part, a filler.

13. A method according to Claim 12 wherein the filler is clay.

14. A method according to Claim 12 wherein the filler is silica.

15. A method according to Claim 12 wherein the filler is magnetisable particles.

16. A method according to ~~any one of the preceding Claims~~ Claim 1 wherein the power output of the lamp is at least 180 watts/cm.

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17. A method according to Claim 16 wherein the power output of the lamp is substantially 240 watts/cm.

18. A method according to ~~any one of the preceding Claims~~ Claim 1 wherein UV light from the lamp has a substantial spectral content in the range of 200-300 nm.

19. A method according to Claim 18 wherein UV light from the lamp has a spectral content at peaks of approximately 370 nm, 408 nm and 438 nm.

20. A method according to ~~any one of the preceding Claims~~ Claim 1 wherein two lamps are provided in the curing zone, the lamps having different spectral properties.

21. A method according to ~~any one of Claims 1 to 19~~ Claim 1 wherein two lamps are provided in the curing zone, the ~~lamps having substantially~~ identical spectral properties.

22. A substrate when coated by a method according to ~~any one of the preceding Claims~~ Claim 1.